

Work Order ID 85868

85868

Page 1

June-18-12 10:51:12 AM

Item ID: D3257-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 15/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3257	Rev B								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 0.500" x 0.500" x 1.180" long Bar								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA420 and Dwg D32571-Deburr2- *****FINISH TAPPING PARTS BY HAND AS PER DWG D3257*****								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

85 12 08-18 (10)

10 12/08/21

10 0

10 12/08/21

10 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fitting

Stop *NS2*

Start Date: 15/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

24 12. P 22

10

1

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location 036

0.00

50

10

8

12/8/23

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

MJS 12/08/23

150

QC

Memo

0.00

Quality Control

UMF

12-08-23

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NOTE: Date & initial all entries

Picklist Print

June-18-12 10:51:16 AM

Page 1

Work Order ID: 85868

85868

Parent Item: D3257-1

D3257-1

Parent Item Name: Fitting

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A04.04.14New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.500X0.500		Purchased	No			100	f	17.6309	0.1092	1.149474			

M303B0 500X0 500

AISI 303 Bar .500 x .500

**

CT 12.08.18

Location

Loc Qty

Loc Code

MAT050

17.6309

111571

5.6309

121157

12

1.149474

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NOTE: Date & initial all entries

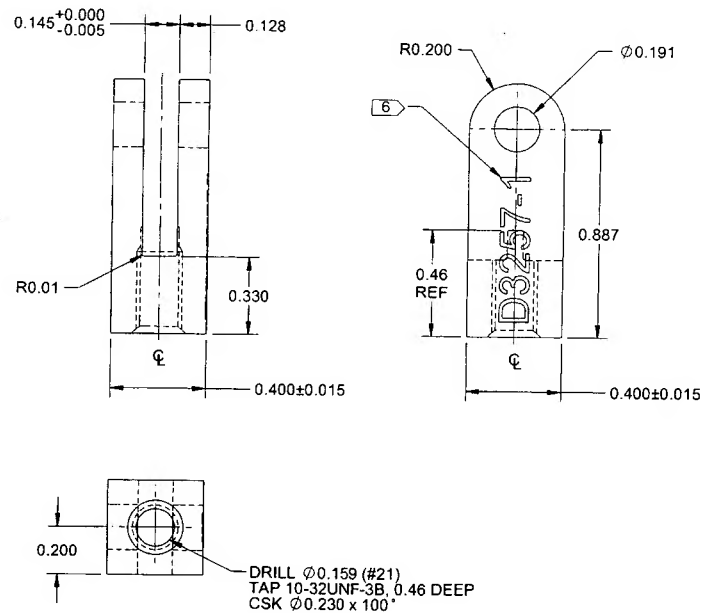
Dart Aerospace Ltd

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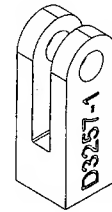
NOTE: Date & initial all entries



D3257-1 FITTING

NOTES:

- 1) MATERIAL: AISI 303/304/316 SS BAR
PER ASTM A582 (303)
PER ASTM A276 OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.3
- 7) WEIGHT: 0.03 lbs



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85868 MJS
12/06/18

RELEASED
2012-03-21
ECN 12-545 CP

B	RE-DESIGN PER PART 12-162	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3257 REV: B SHEET 1 OF 1 TITLE FITTING SCALE NTS DATE 12.02.24	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.02.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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